

Work Order ID 122877

Tuesday, July 29, 2014 2:24:57 PM

122877

Page 1

Item ID: D2013-6 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mirror Bracket RH, 204
 Start Date: 7/29/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/29/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Wm Date: 7/30/14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2013	Rev C

100 NC BRAKE 0.00
100
 Brake NC
 Brake NC
 Memo 0.00
 1-Punch as per template D2013-T5 and Dwg D2013
 2-Flatten ends of D2013-6 tube as per Dwg D2013 using DT8545 3-Bend tube
 as per Dwg D2013 using Jig DT8201
 Identify as D2013-6.
 4-Deburr as required

4/x DAS
28 JAN 13 2015
9-89

110 QC5- Inspect part completeness to step on W/O 0.00
110
 QC
 Quality Control
 Memo 0.00

(4) DAS
38 JAN 15 2015
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <u>WAC001</u>	0.00				4			
120									
Packaging	Memo	0.00							
Packaging									
130	QC21 - Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

JAN 16 2015 DAS 06 9-89

15/1/1998

15.1-19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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Picklist Print

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Page 1

Work Order ID: 122877

122877

Parent Item: D2013-6

D2013-6

Parent Item Name: Mirror Bracket RH, 204

Start Date: 7/29/14

Required Date: 7/29/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	535.6861	1.73	8			
M304TR0 750W 049										**	DAS 28 9-89	JAN 13 2015	
304 RD Tube .750 x .049W													

Location

Loc Qty

Loc Code

MAT017

535.6861

124768

49.27

M126183

1.4399

M128084

38.9762

M129188

46

M129363

400

~~130272 *2~~

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

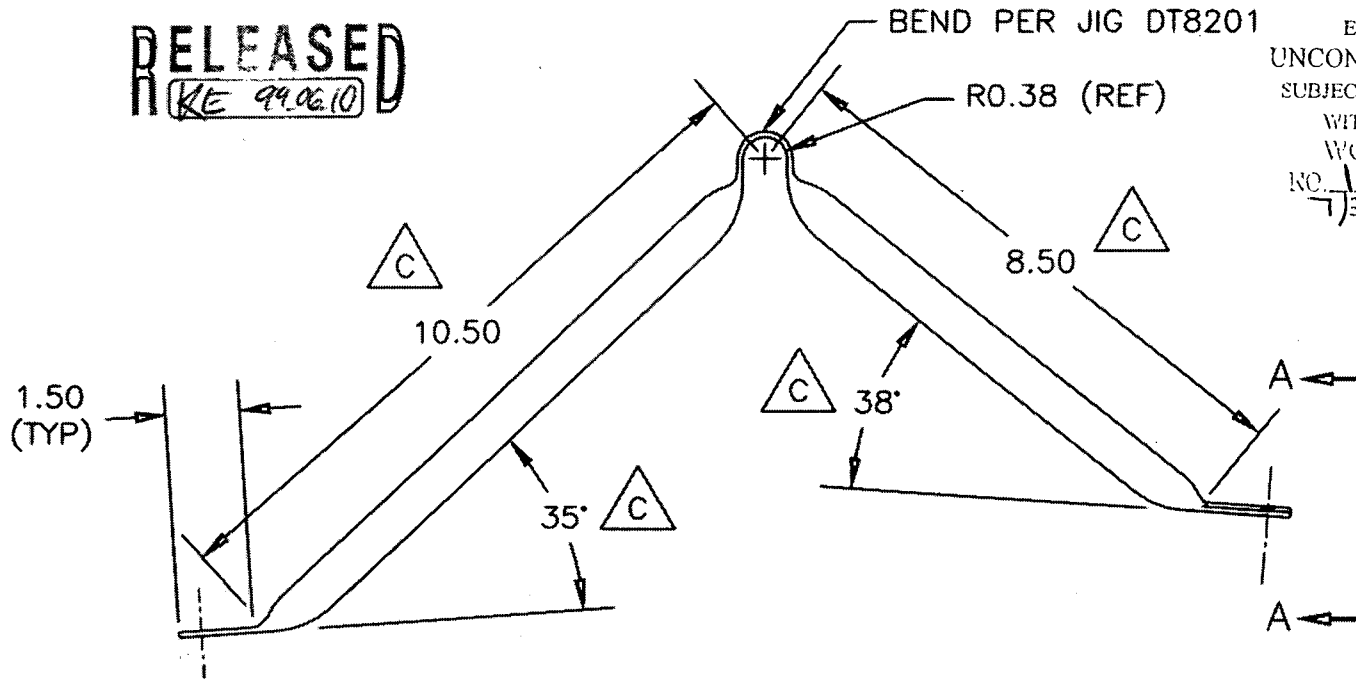
FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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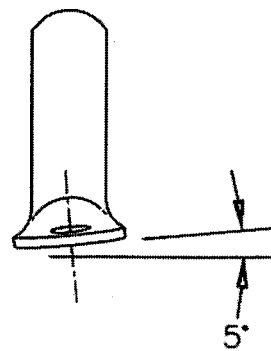
RELEASED
KE 99.06.10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 132817
7/30/14 wcm

DART



D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)



VIEW A-A

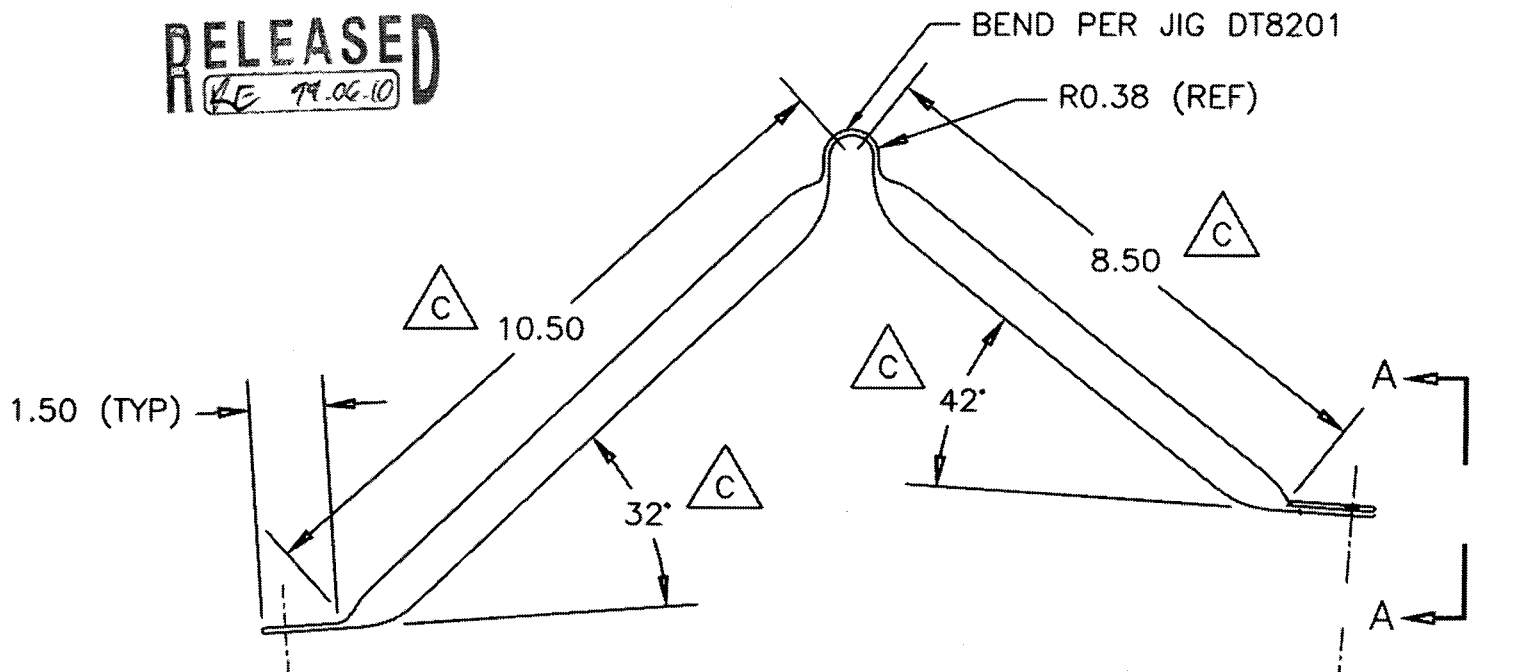
DRILL $\phi 0.257$ (TYP)
0.400 (TYP)

CUT LENGTH: 23.25 INCHES

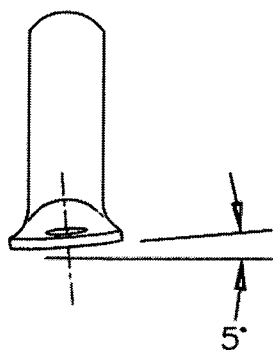
MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

DESIGN	JB	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	AE	APPROVED	RT
DATE	99.06.07	TITLE	MIRROR BRACKET
			REVISIONS
A	90.10.22	NEW ISSUE	
B	94.06.15	REDRAWN	
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS	
		SCALE	NTS
		SHEET 1 OF 3	
		REV. C	

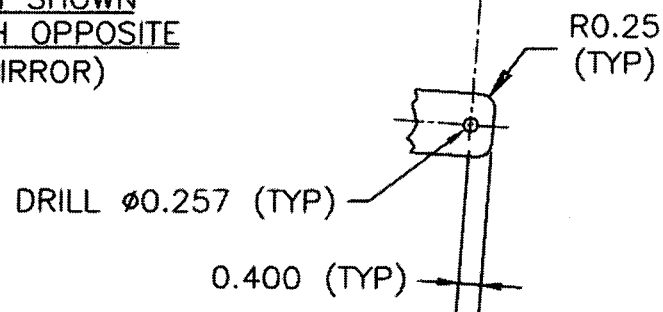
RELEASED
KE 79.06.10



D2013-3 LH SHOWN
D2013-4 RH OPPOSITE
(FOR 212 MIRROR)



VIEW A-A



CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

DART

QA CONTROL

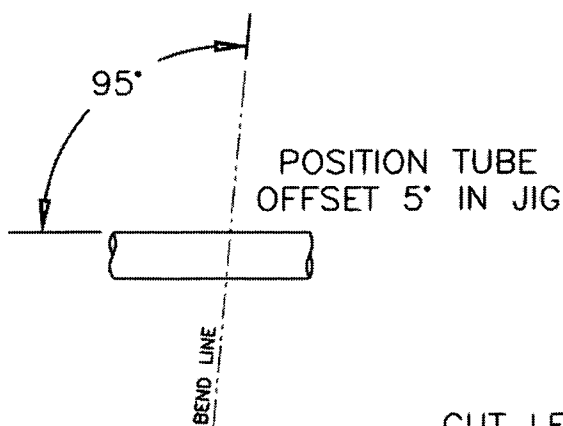
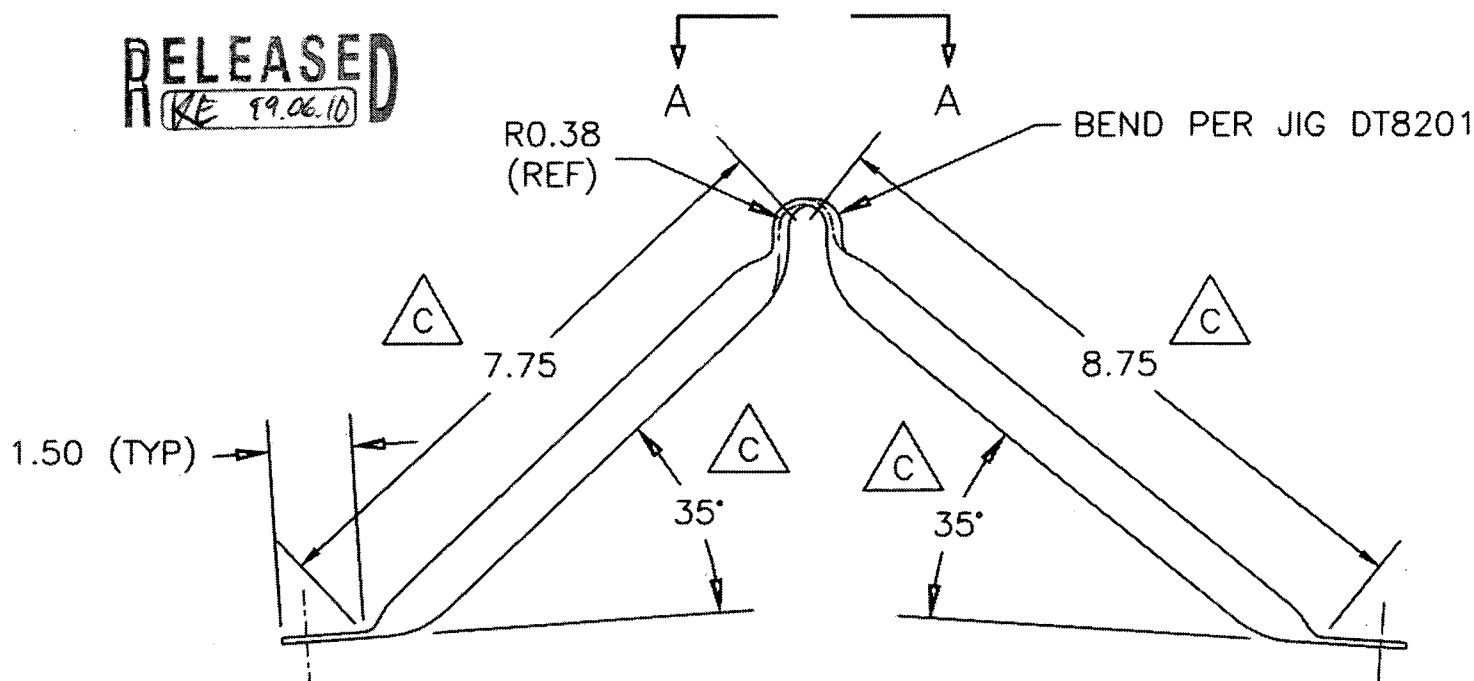
DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	APPROVED	[Signature]	DRAWING NO.	D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	SHEET 2 OF 3	REV. C
		SCALE	NTS		

RELEASED
KE 19.06.10

DART

QA COPY ISSUED

DESIGN	JB	DRAWN BY	KE	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	
DATE	99.06.07	DRAWING NO.	D2013	REV. C
		TITLE	MIRROR BRACKET	SHEET 3 OF 3
				SCALE
				NTS



D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)

DRILL $\phi 0.257$ (TYP)

0.400 (TYP)

R0.25 (TYP)

CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

